SLAUTTERBACK®

KB Series Handgun

Hot Melt Supply Units

Models KB 10G and KB 20G

Part Number: 19600-41POLY

SERVICE MANUAL

"KB" SERIES HANDGUN

HOT MELT SUPPLY UNITS

MODELS KB 10G AND KB 20G

SLAUTTERBACK CORPORATION

MANUAL NUMBER: 19600-41POLY

NO REVISION

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*** NOTES ***

1 Safety Precautions for Hotmelt Applicator Equipment

This manual contains important safety information and instructions. Failure to comply with these instructions can result in death, injury or permanent damage to this equipment and will void the warranty.

1.1 Intended Use

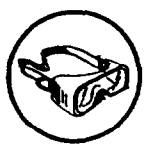
This equipment is designed for use with standard adhesive and sealant materials with flash points above 232 °C (450 °F). Use of flammable material or material not compatible with the specifications of this equipment can cause injury to operator and damage to equipment.

The manufacturer has designed this equipment for safe operation. Specified models are in compliance with EN 60204-1:1997. However, heated thermoplastics and other hotmelt materials are dangerous and care must be exercised to ensure operational safety. Handling must be in accordance with hotmelt manufacturer specifications. Never exceed the maximum application temperature recommended by the adhesive manufacturer.

Dispose of hotmelt properly. Refer to the Materials Safety Data Sheet (MSDS) of the hotmelt for recommended disposal methods.

1.2 Personal Safety

Wear the following protection when working on or around this equipment:



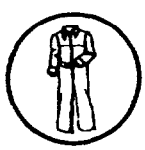
Wear Safety Goggles

Always wear heat resistant gloves rated to 205 °C (400 °F) and allow all system temperatures to stabilize below 193 °C (380 °F) before servicing. Properly ventilate equipment according to MSDS of the material used. Do not store combustible materials in vicinity of equipment.

Wear Heat-Resistant Safety Gloves

Trained operators and service technicians should be aware of exposed surfaces of the unit which cannot be practically safeguarded. These exposed surfaces may be hot and take time to cool after the unit has been operating.

Keep parts of the body away from rotating parts. Do not wear loose articles of clothing when operating or servicing units with rotating parts. Remove wristwatches, rings, necklaces, or other jewelry and cover or pin up long hair before performing any work on or with the unit.



Wear Protective Clothing

Trained operators may perform only external equipment adjustments. Internal adjustments and service must be performed by trained service technicians.

1.3 Electrical Safety

Determine voltage of this equipment before installation and confirm compatibility with available power. Equipment must be connected to a properly grounded circuit and installed in accordance with all applicable electrical codes. Ground fault protection must be provided in supply circuitry at site installation.

Models designed to EN60204-1:1997 require power cords be approved to a harmonized (HAR) standard and rated for 70 °C (158 °F). A HAR approved Type B plug and strain relief for power cord are required to meet standard IEC 309. Power conducting wires must be nominal 5.3 mm² (10 AWG) maximum and nominal 2.1 mm² (14 AWG) minimum.

1.4 Emergency Power Disconnect

In the event of a malfunction, turn off power to the equipment at the power off switch and remove source power to the system at the nearest main disconnect.

1.5 Follow Directions

Read the product manual thoroughly before installation, operation or maintenance. Failure to do so can result in a serious accident or equipment malfunction. **The manufacturer will not be held liable for injuries or damage caused by misuse of this equipment.**

1.6 Safety Symbols and Signal Words

The following safety symbols and signal words are used throughout the manual and on the product to alert the reader and operator to personal safety hazards or to identify conditions that may result in equipment or property damage.

General Safety Symbols

DANGER Indicates a hazard which, if not avoided, will result in serious injury, including death, or equipment and property damage.

WARNING Indicates a hazard which, if not avoided, can result in serious injury, or equipment and property damage.

CAUTION Indicates a hazard which, if not avoided, can result in minor injury, or equipment and property damage.

Specific Symbols and Signal Words

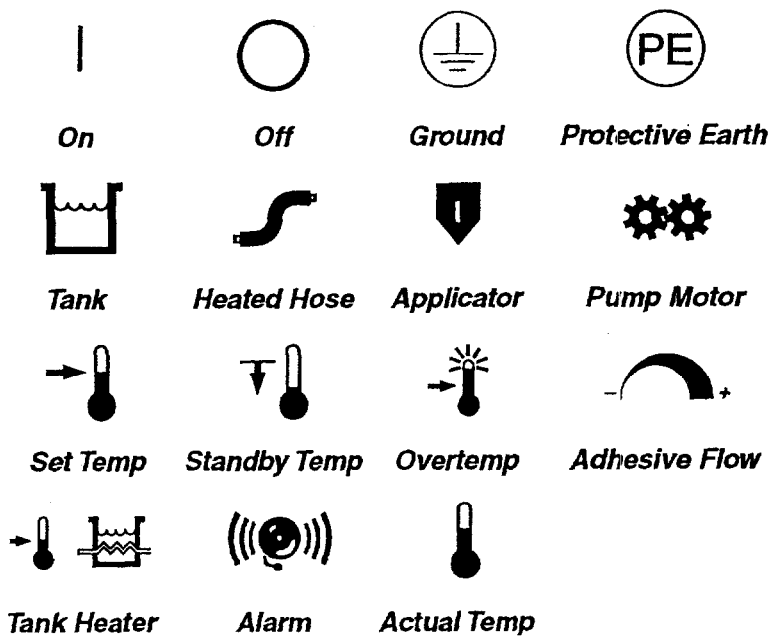
DANGER High Voltage. Can cause serious injury, including death. Disconnect electrical power at external source before servicing.

WARNING Hot Surface. Can cause serious injury and burns. Wear heat resistant clothing, gloves and safety goggles.

WARNING Disconnect electrical power at external source. Failure to do so can cause electrical shock.

WARNING High Pressure. System contents under pressure. Can cause serious injury and burns or equipment and property damage. Relieve pressure before servicing.

Other Product Symbols



The manufacturer reserves the right to make design changes for product improvement. This manual may not reflect all details of these improvements.

A

DESCRIPTION

The Slautterback KB Series Hot Melt Supply Units are "high flow", high pressure machines used for the melting and pumping of hot melt thermoplastic adhesives. These units consist of a heated tank and a motor-driven positive displacement gear pump. They are all electric and do not require the use of compressed air. Models are available with 10 and 20 lb. capacity tanks. (30 lb. units are covered in service manual #19600-11, and 50 and 100 lb. units are covered in service manual #19600-44)

KB Series "G", or "HANDGUN" Version machines are designed for use with Slautterback handgun/hoses. One gun hanger switch per hose may be mounted on the side of each machine - machines with "switched" handgun/hoses (Model L1S) are not equipped with gun hanger switches. The 10 and 20 lb. units are capable of using one or two handgun/hoses.

KB Series machines are able to pump a variety of hot melt materials, such as packaging adhesives, product assembly adhesives, and thermoplastic potting materials (see Section B.3, Performance Specifications). The melt tank will accept granular, flake, or chunk forms of hot melt adhesives.

All units are equipped with a flow control valve which provides precise fluid pressure regulation. An internal tank melt grid is standard in the KB 10G and KB 20G.

The tank temperature can be regulated from ambient temperature to 400° F (205° C). An adjustable tank controller is mounted directly to the melt tank base.

Hose temperatures are individually controlled by adjustable capillary bulb controllers mounted on the inside electrical panel of the melt unit.

Electrical power to the unit is controlled by a circuit breaker mounted directly on the front panel. Other front panel features include a tank temperature meter, a pump on/off switch, a tank heating indicator light, and an overtemperature indicator light. Hose Power switches are located on the lower right portion of the front panel. (two maximum)

The inside electrical panel of the KB Series machine contains terminal blocks to make electrical connections for the "power-in" supply circuit. (Refer to Section D.5, Electrical Hook-up.)

DESCRIPTION CONTINUED

KB Series "G" Version models are available in two wiring arrangements. The KB "PREWIRE" model comes complete with a power cord for "power-in" to the melt unit. Power cords for 120 volt units have a standard three prong plug - 240 volt units have 4 wire power cords where the customer must supply the appropriate power plug. The KB Series "CONDUIT" model allows the user to make hard-wire connections (power cord not included). This unit has knockout holes in the chassis and terminal strips on the electrical panel for liquidtight conduit installation.

The following safety features are included with each melt unit:

- A tank mounted overtemperature switch turns the tank heaters off in the event of a tank thermostat failure.
- The pump motor is protected by a circuit breaker which turns the motor off should a stall or an overload condition occur.
- The melt tank is also equipped with a warm-up switch, for the protection of the pump-drive mechanism.

Like other Slautterback products, the KB Series "G" Version melt unit is designed with simplicity and reliability in mind. Troubleshooting, maintenance, and service are quite easy in comparison with competitive equipment. All components are easily replaced using ordinary hand tools.

B

SPECIFICATIONS

B.1 ELECTRICAL SPECIFICATIONS

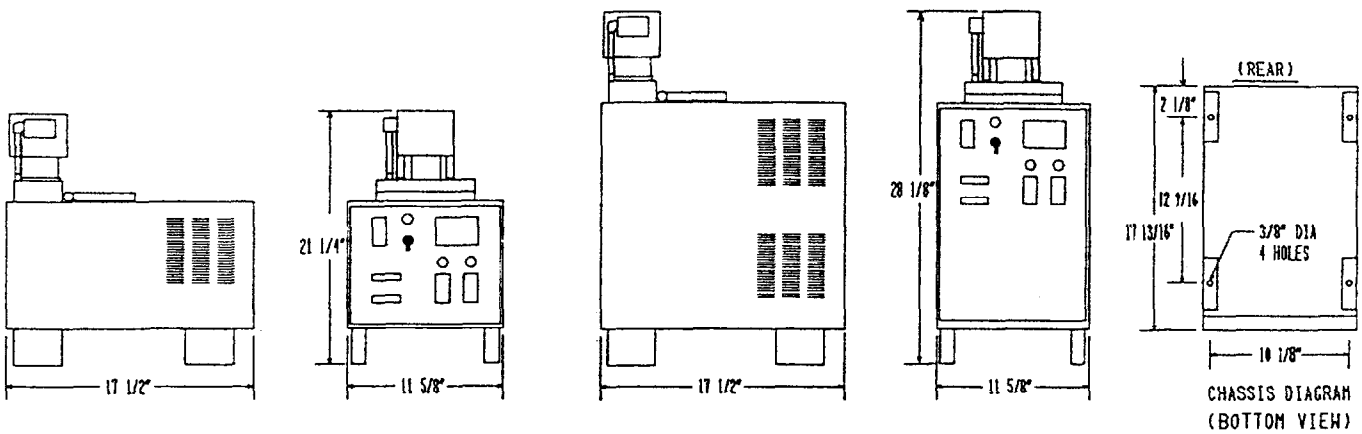
	KB10	KB20
Melt Unit Voltage	120 volt single phase 240 volt single phase (2 or 3 wire)	
Frequency	50-60 Hz	
Power Required (hoses not included)	800 watts	1300 watts
Circuit Breaker Trip	15 amps @ 120V 12 amps @ 240V	20 amps @ 120V 12 amps @ 240V
Controls and Indicators	System On/Off Circuit Breaker Overtemp Safety Limiter and Light Tank Heating Indicator Light Pump Motor On/Off Circuit Breaker Adjustable Tank Temp Controller Adjustable Hose Temp Controller Pump Flow Control Valve Handgun/Hose Power Switch Tank Temperature Meter Gun Hanger Switch (see Section C.1)	

B.2 PHYSICAL SPECIFICATIONS

	KB10	KB20
System Type	Bulk Tank	
Operating Air	None	
Pump Type	Positive Displacement Gear Pump	
Pump-Drive Mechanism	All Electric Motor	
Pump Pressure Regulation	Pump Mounted Flow Control Valve	
Tank Capacity	10 lbs. (4.5 kg)	20 lbs. (8.1 kg)
Hose Capacity	2 hoses	2 hoses
Shipping Weight	32 lbs. (14.5 kg)	62 lbs. (28.0 kg)

SPECIFICATIONS CONTINUED

B.2.1 Dimensional Sketches



KB10 KB20

B.3 PERFORMANCE SPECIFICATIONS

	KB10	KB20
Warm-up Time	30 minutes	
Maximum Melt Rate *	16 lb/hr (7.3 kg/hr)	20 lb/hr (9.1 kg/hr)
Adhesive Viscosity	70000 cps. (maximum)	
Temp Range Melt Tank	Standard: 100 - 400° F (37 - 205° C) Optional: 100 - 450° F (37 - 232° C)	
Temp Range Hose	Standard: 100 - 200° F (37 - 93° C) 200 - 300° F (93 - 150° C) 300 - 400° F (150 - 205° C) 350 - 450° F (175 - 232° C)	
Maximum Pump Flow Rate**	Motor RPM / Pump Size / Output 86 (60 Hz) 21 mm 85 lb/hr (39 kg/hr) 86 (60 Hz) 30 mm 120 lb/hr (54 kg/hr) Note: Motors run @ 50 Hz have 20% less output	
Maximum Pump Pressure**	Motor RPM / Pump Size / Maximum Pressure 86 (60 Hz) 21 mm 700 psi (4827 kPa.) 86 (60 Hz) 30 mm 470 psi (3241 kPa.)	

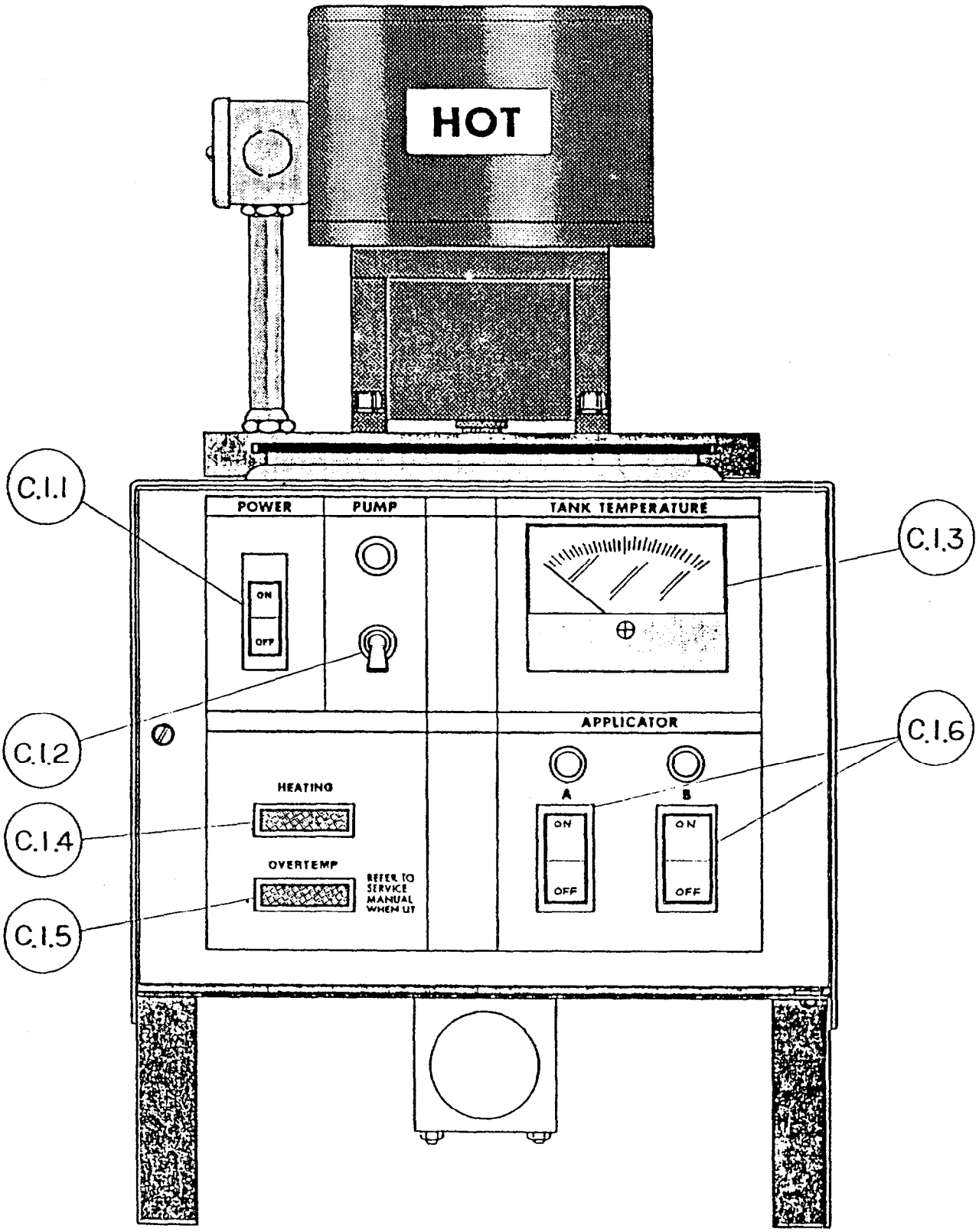
* Maximum melt rates vary with different adhesive types.
** Maximum pump rates are calculated with standard packaging grade adhesives.

C

CONTROLS AND INDICATORS

This section covers the operating controls found on your machine. Please read this section carefully before attempting to operate this machine.

CONTROLS AND INDICATORS CONTINUED



CONTROLS AND INDICATORS CONTINUED

C.1 Front Panel

C.1.1 System Power Switch and Circuit Breaker

This magnetic type breaker illuminates when turned on. At 120 vac, it is designed to trip at currents exceeding 20 amps (for KB 20) or 15 amps (for KB 10). The slightly larger 240 vac breaker will trip at currents exceeding 15 amps. These ratings are common for both the 10 lb. & 20 lb. models.

C.1.2 Pump On/Off Breaker Switch

Allows user to shut off pump motor during warm-up and during system maintenance. This switch is also a circuit breaker for pump motor overload protection. The pump switch must be in the "ON" position in order to make handgun actuated switching devices, such as a gun hanger switch, operable.

***** NOTE *****

EACH KB "G" VERSION MELT UNIT HAS A SWITCHED PUMP MOTOR ELECTRICAL CIRCUIT. POWER TO THE PUMP MOTOR CAN BE SWITCHED FROM A LOCATION OTHER THAN THE MELT UNIT FRONT PANEL. THIS CAN BE A SWITCH ON THE HANDGUN/HOSE APPLICATOR OR A GUN HANGER SWITCH MOUNTED ON THE SIDE OF MELT UNIT (NOT SHOWN). REFER TO SECTION D.5.2 FOR FURTHER DETAILS.

C.1.3 Tank Temperature Meter

This thermocoupled temperature meter indicates hot melt temperature in the tank. It does not indicate temperature of material in the hose.

C.1.4 Tank Heating Indicator Light

This light turns on when tank heaters are powered. It also assists the user when making accurate adjustments to the tank temperature controller.

C.1.5 Overtemperature Indicator Light

This is a safety feature. The KB Model is fitted with an overtemperature shut-off which turns tank heaters off if tank temperature exceeds approximately 450 F. The light will indicate an overtemp condition. Should this light turn on, the tank temperature control should be turned down or replaced if it has failed. (See Section G, Troubleshooting.)

CONTROLS AND INDICATORS CONTINUED

C.1.6 Handgun/Hose Power Switch

This switch is used for turning power ON or OFF to the handgun/hoses. It allows the melt tank to remain powered while system maintenance is being performed. Up to two handgun/hose power switches are mounted in the front panel for individual hose power control.

D

INSTALLATION INSTRUCTIONS

***** NOTE *****

TOOLS USED FOR INSTALLATION ARE SPECIFIED IN SECTION I.4

D.1 Shipping and Handling

The hot melt supply unit is bolted to a plywood board the size of the bottom of the shipping carton.

The unit may be shipped with handgun/hoses attached. The hoses are carefully coiled around the machine and the handguns are wrapped in corrugated envelopes. The corners of the unit are protected with corrugated upright inserts. A plastic envelope, containing the system manuals and warranty information sheets, along with the 1/4 inch hex key for the flow control valve, are placed in the carton. A corrugated cardboard piece the size of the box top is placed in last, and the box flaps are sealed.

D.2 Supporting the Melt Unit

Position the melt unit so that it is convenient for servicing and the control panel is easily accessible. Using the base mounting holes, bolt the melt unit down to the surface where it will be used. The mounting surface must be level and flat so as to prevent warping of the unit and misalignment of the pump and motor shaft.

***** WARNING *****

MELT UNIT MUST BE PROPERLY BOLTED DOWN TO PREVENT ACCIDENTAL UPSET AND POSSIBLE INJURY.

D.3 Component Installation

D.3.1 Hot Melt Supply Hoses

***** CAUTION *****

IN ORDER TO PREVENT DAMAGE TO THE HOT MELT SUPPLY HOSE, THE HOSE SHOULD NOT BE FLEXED WHEN COLD. THESE HOSES HAVE A MINIMUM BEND RADIUS OF EIGHT INCHES (WHEN HOT). FURTHER FLEXURE WILL CAUSE PERMANENT DAMAGE.

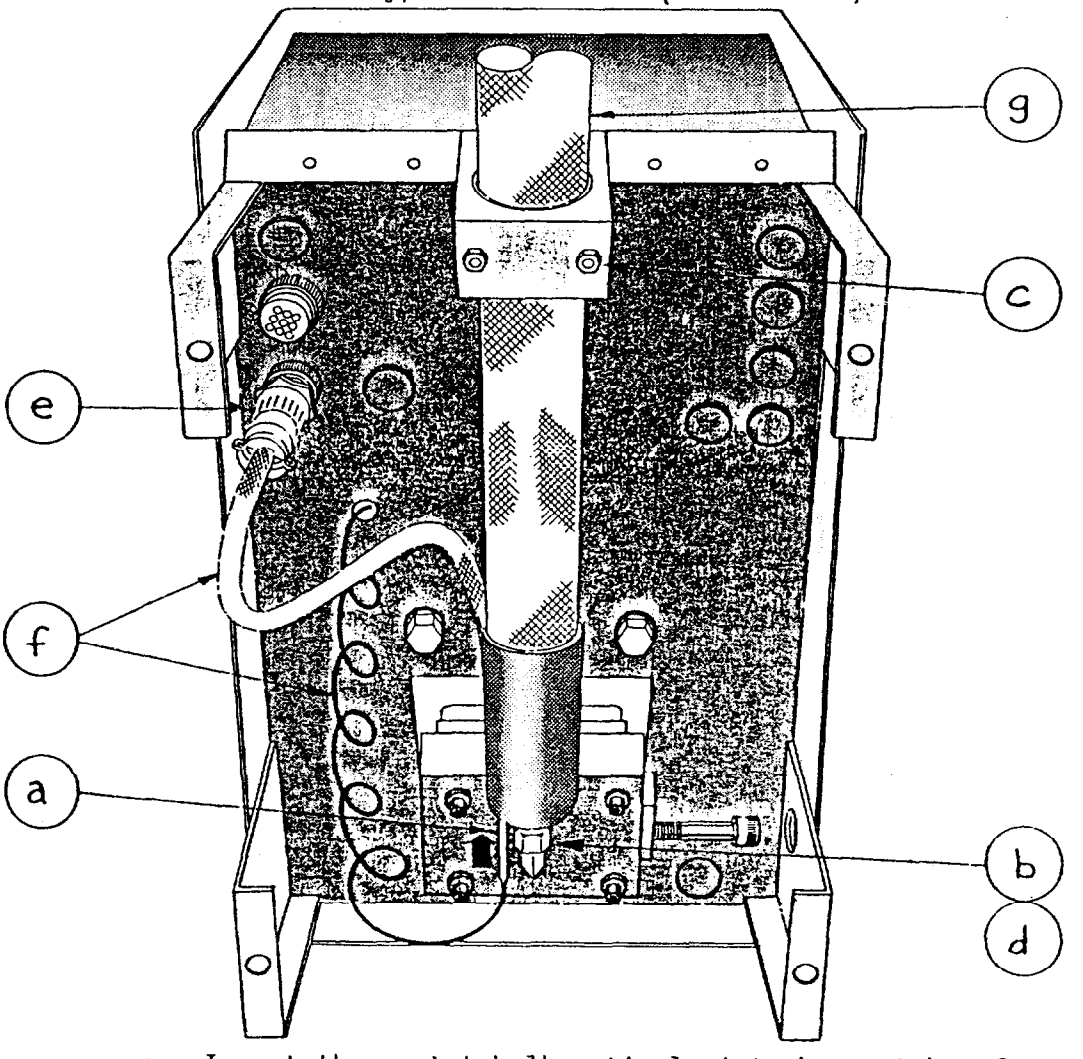
HOT MELT FITTINGS MUST BE HEATED BEFORE LOOSENING OR TIGHTENING OR DAMAGE MAY RESULT. (NEW, CLEAN SUPPLY HOSE FITTINGS DO NOT NEED TO BE HEATED.)

***** NOTE *****

TO INSTALL HOT MELT HOSES ON THE MELT UNIT, RAISE OR TILT THE UNIT BACKWARDS FAR ENOUGH WHERE ADHESIVE WON'T SPILL AND SO THAT THE BOTTOM IS ACCESSIBLE. DO NOT TURN THE MACHINE UPSIDE DOWN.

INSTALLATION INSTRUCTIONS CONTINUED

FIGURE D.3.1 Typical Melt Unit (Bottom View)



a. Insert thermostat bulb entirely into brass tube of hose. Take care not to kink the capillary tube and not to bend the hose at a sharp angle.

b. Loosely connect JIC swivel fitting on hose to the right angle fitting on the hose connection manifold.

c. Fasten hose support block to chassis.

d. Tighten JIC swivel fittings.

e. Plug in hose electrical connectors.

f. Tuck capillary tubing and electrical connector up underneath the unit.

g. Position and support hose as it will be used in service. (See caution note on the next page)

INSTALLATION INSTRUCTIONS CONTINUED

***** CAUTION *****

FAILURE TO PROPERLY SUPPORT HOSE WILL RESULT IN PREMATURE FAILURE. SUPPORT HOSE TO PREVENT EXCESSIVE FLEXURE. DO NOT SUPPORT HOSE IN ANY WAY WHICH RESULTS IN ADDING ADDITIONAL THERMAL INSULATION OR OVERHEATING WILL RESULT.

ALWAYS CHECK CALIBRATION OF HOSE TEMPERATURE AFTER INSTALLING A NEW OR DIFFERENT HOSE. HOSES CAN VARY AND EACH HOSE CAN PRODUCE DIFFERENT TEMPERATURE RESULTS.

D.4 Wiring Arrangements

D.4.1 Prewired

KB Series "G" Version prewired melt units come **completely wired** with all necessary internal electrical connections, remote pump motor switches, external hose connectors, and an 8 ft. power cord. The 120V melt unit power cord has a standard U.S. domestic three prong plug attached. The 240V prewired melt unit has a 4 wire power cord - user must provide a 240V power plug for appropriate 240V power supply (2 or 3 wire - see Section D.6.) HANDGUN melt units with power cords, or prewired units, can allow a system to be mobile in a facility from work station to work station.

D.4.2 Conduit

Conduit models also come wired with the required internal electrical connections, remote pump motor switches, and external hose connectors (**power cords are not included**). "Power-in" must be hard-wired by the user inside the melt unit. (See Section D.5, Electrical Hookup.)

D.5 Electrical Hookup - Handgun/Hoses

Those units which are PREWIRED come equipped with an 8' power cord. The system becomes fully operable by simply plugging in the power cord to the proper power supply socket. An appropriate power plug must be attached to the power cord for 240V melt units. Inspect the melt unit (I.D. plate and inside electrical panel) to verify the actual type of 240V power plug required for the system (2 or 3 wire). (See Section D.6, Power Requirements)

For CONDUIT model hookup, it is necessary to open the front control panel. Then the appropriate "power-in" wires must be installed in the terminal blocks provided. Slautterback Corporation suggests the use of 3/8" liquidtight conduit and fittings when routing wires to the electrical terminal blocks. 7/8" diameter holes in the chassis are provided for these installations. (See Section D.6, Power Requirements.)

Note: Close the front control panel after electrical hookup.

INSTALLATION INSTRUCTIONS CONTINUED

D.5.1 Hose Power Circuit

The KB 10G and KB 20G front panels have two applicator control switch locations for one or two handgun/hose power switches. Hose Power switches are identified by the "ON/OFF" markings imprinted in the switch body.

A **Hose Power Switch** controls the electrical power to hose and handgun heaters in a handgun/hose. Each hose power switch on a KB Series "G" Version machine controls individual handgun/hoses (up to two).

Not only are hose power switches useful during system maintenance, but they are also useful in different work station arrangements. One handgun/hose can be turned OFF at a work station when it is occupied by only one operator. This can conveniently increase handgun/hose life when it is not being used.

D.5.2 Switched Pump Motor Circuit

The Switched Pump Motor Circuit allows the pump motor to be switched OFF with a handgun when the system is not applying adhesive. This feature increases pump motor life. The remote pump switch can be found on a switched handgun, such as the Model L1S, or at the gun hanger switch mounted on the side of the melt unit. Both of these switches turn ON the pump motor at the time of application. Up to two remote switches are wired in the melt unit between terminal block locations TA-9 and TA-9a. (Refer to Section H.2.)

D.6 Power Requirements

KB Series melt units are standard single phase versions of 120 volt or 240 volt power sources, each with earth ground for safety. The 240 volt units can be wired for **2 wire or 3 wire** single phase power. (See the following Block Diagrams.) An identification plate is attached to each melt unit on the inside of the left rear leg of the tank chassis. This plate specifies the exact voltage of the melt unit and the frequency of the pump motor (50 Hz or 60 Hz).

***** CAUTION *****

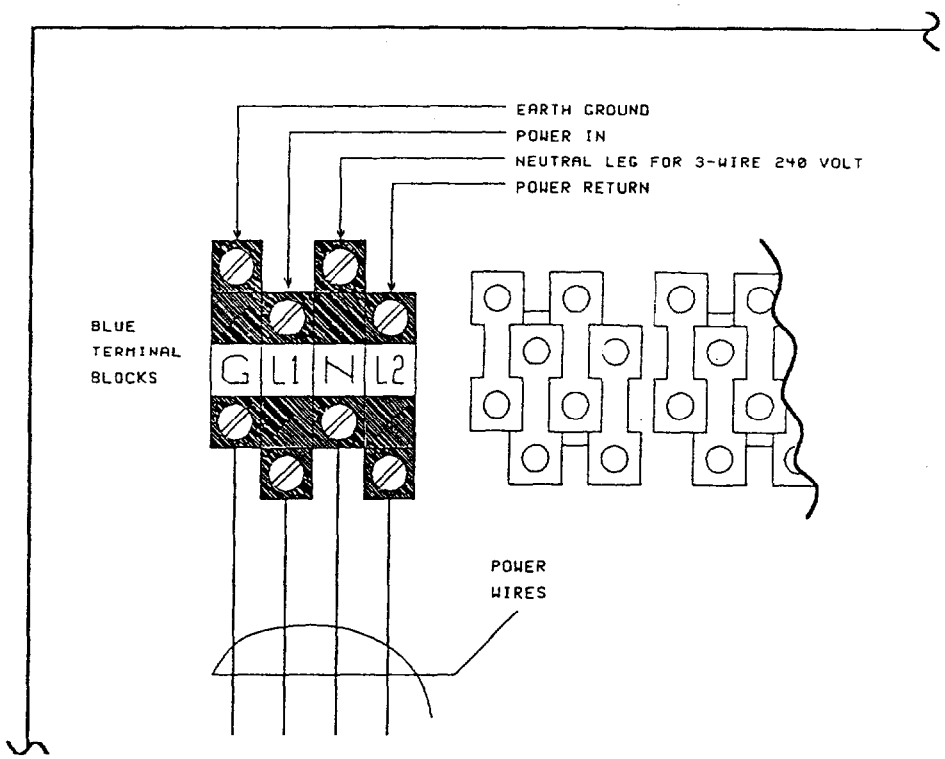
BEFORE CONNECTING ELECTRICAL POWER TO THE MELT UNIT, REFER TO THE MELT UNIT'S **IDENTIFICATION PLATE**. ALSO REFER TO SECTION B.1 OF THIS MANUAL FOR FURTHER MELT UNIT ELECTRICAL SPECIFICATIONS.

***** CAUTION *****

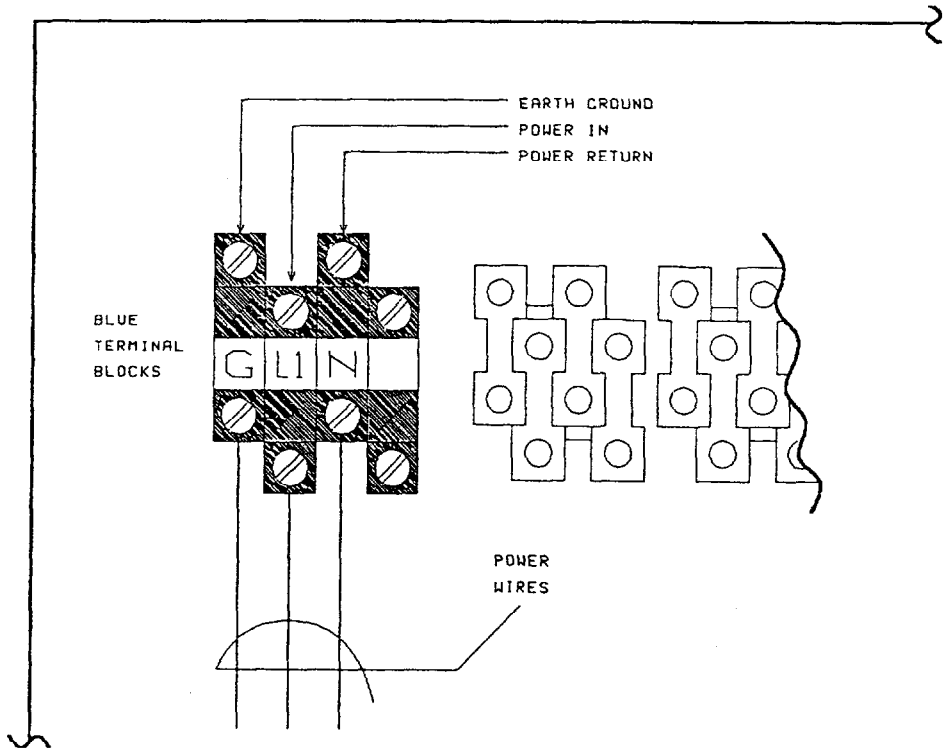
THE PUMP WARM-UP SWITCH, FOUND AT THE REAR OF THE UNIT, IS A SAFETY DEVICE WHICH PROTECTS THE PUMP-DRIVE MECHANISM. **DO NOT** BYPASS THIS ELECTRICAL CIRCUIT OR DAMAGE MAY RESULT TO THE MELT UNIT.

INSTALLATION INSTRUCTIONS CONTINUED

D.6.1 Block Diagram 240 Volt Single Phase



D.6.2 Block Diagram 120 Volt Single Phase



INSTALLATION INSTRUCTIONS CONTINUED

D.7 Start-up Instructions

1. Become familiar with controls by reading Section C, Controls.
2. Install the KB melt unit as specified in this section.
3. Fill tank with hot melt material to 1-1/2 inches from top.
4. Turn the unit on and allow 30 minutes warm-up time.
5. Set hose and tank temperatures to desired settings. Lower settings will increase the material's pot life.

Note: Certain product assembly materials will degrade over time due to oxidation. It is best not to put more material in the tank than will be used in one day. Set the tank temperature as low as feasible for each specific application. To prevent stalling of the motor, adjust the flow control valve so the pump is partially bypassed.

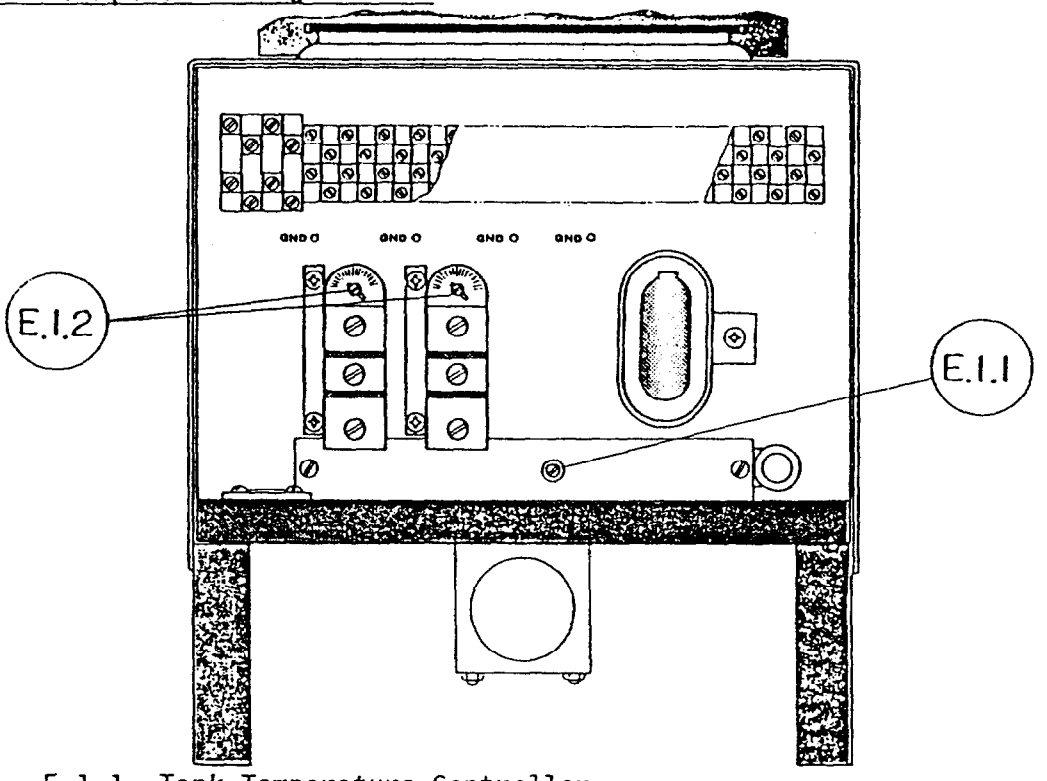
***** CAUTION *****

DO NOT MIX DIFFERENT HOT MELT FORMULATIONS WITHOUT FIRST TESTING OUTSIDE THE TANK. SOME COMBINATIONS TEND TO JELL AND THICKEN. DRAIN THE SYSTEM IF NECESSARY AND CLEAN TANK AND HOSES WITH A FLUSHING AGENT SUCH AS "STRIP N CLEAN". (SEE SECTION I.5, LUBRICANTS/SEALANTS/CLEANERS.)

E

ADJUSTMENTS

E.1 Temperature Adjustments



E.1.1 Tank Temperature Controller

To raise tank temperature, turn shaft clockwise. To lower tank temperature, turn shaft counter-clockwise. The tank controller temperature ranges 575° F in one 320° rotation of the adjustment shaft. Use the tank temperature meter to verify temperature. Allow temperature to stabilize at least 30 minutes before making further adjustments.

Note: To prevent degradation of the hot melt material, the tank temperature should be as low as possible for the material used. See Section B.3, Performance Specifications for temperature range of the melt tank.

E.1.2 Hose Temperature Controllers

To raise hose temperature, turn shaft clockwise. To lower hose temperature, turn shaft counter-clockwise. Temperature graduations on hose controllers reflect the approximate hose temperature. For precise readings, measure the inside hose temperature with a pyrometer and bead probe, such as the Slautterback Teletherm. (See "Temperature Check" in the Maintenance Section of the supply hose service manual.) Hose temperature should be the minimum temperature required for application for maximum hose life and to prevent degradation of the material in the hose.

ADJUSTMENTS CONTINUED

E.2 Flow Control Valve

The flow control valve is an adjustable pressure regulating device mounted to the pump underneath the melt unit chassis. It is adjusted from the lower right side of the melt unit, using the 1/4 inch hex key supplied with the unit.

Adjust for the following conditions:

Maximum Flow - Low Viscosity Materials

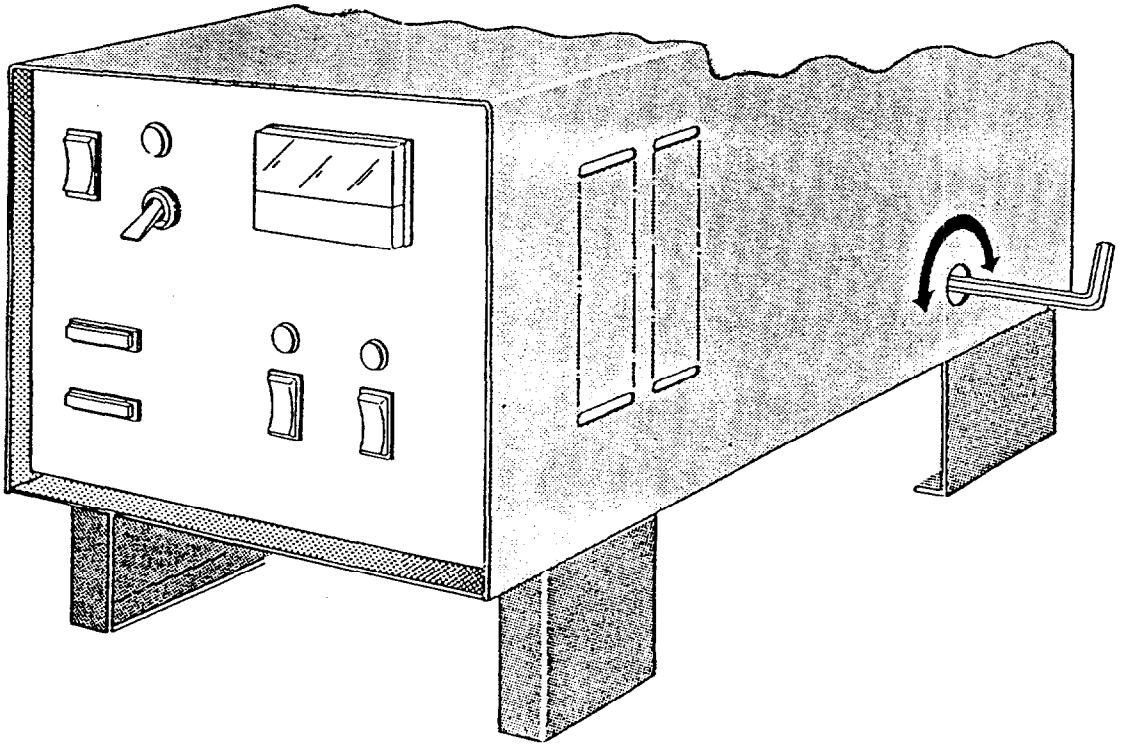
Adjust 1/2 to 1 turn counter-clockwise from full clockwise setting. This will prevent pressure surges when system is valved open.

Maximum Flow - High Viscosity Materials

Adjust so pump will start and run at normal speed when switched on with the system valved shut.

Adjusting for Lower Flow Rates

Adjust for desired flow rate when system is valved open.



FLOW CONTROL VALVE ADJUSTMENT
(See Caution Note on next page)

ADJUSTMENTS CONTINUED

*** CAUTION ***

FOR MAXIMUM PERFORMANCE AND MOTOR LIFE, DO NOT ALLOW PUMP MOTOR TO STALL. PROLONGED STALL CONDITIONS WILL CAUSE MOTOR TO GO INTO THERMAL OVERLOAD.

E.3 Electrical Adjustments

Once electrical power has been properly supplied to the inside electrical panel (according to Section D.6), the melt unit needs no further electrical adjustments. KB Series "G" Version melt units are designed to be "electrically simple."

*** NOTES ***

F

MAINTENANCE

F.1 Summary

KB Series Hot Melt Supply Units require monthly temperature checks per Section F.4. Should char buildup occur, or if the hot melt formulation is changed, the system should be purged with a flushing agent such as Slautterback "Strip-N-Clean". Before attempting any maintenance procedure, read the Warning and Caution Notes in Section F.2.

F.2 Warning and Caution Notes

***** WARNING *****

HOT MELT MATERIALS CAN CAUSE SEVERE BURNS RESULTING IN DISFIGUREMENT OR BLINDNESS...

Take the following precautions:

1. Wear eye protection goggles, gloves, and protective clothing.
2. Turn pump switch to the "OFF" position. Depressurize the handgun/hose by pulling the gun trigger. Take care to position the handgun towards a disposal container.
3. Always disconnect hose electrical connector when hose fittings are disconnected. When a hose is allowed to heat with the fittings disconnected, heat expansion of the hot melt will cause high pressure inside the hose.

***** CAUTION *****

TO PREVENT DAMAGE TO COMPONENTS (HOSE FITTINGS, ETC.), THE SYSTEM, SPECIFICALLY THE PART BEING SERVICED, SHOULD BE HEATED TO APPROXIMATELY 250° F PRIOR TO DISMANTLING, ASSEMBLY, OR ADJUSTMENT. FAILURE TO DO THIS WILL RESULT IN STRIPPING OF THREADS AND RUINING BOTH PARTS AND TOOLS.

***** CAUTION *****

TO AVOID ARCING OF ELECTRICAL CONTACTS AND POSSIBLE FAILURE OF COMPONENTS, DO NOT CONNECT ELECTRICAL CONNECTORS WHEN THE HOSE POWER SWITCH IS "ON".

MAINTENANCE CONTINUED

F.3 Heating of Parts

Heating parts may be accomplished by:

- Applying power to the unit.
- Using a hand held hot air gun.
- Placing parts on a hot plate.

F.4 Monthly Inspection Procedure

F.4.1 Hose Inspection

1. Verify that the hose is being properly supported so it is not over-stressed during use. (Minimum bend radius is 8 inches.)

2. Check temperatures and adjust as required per Section E.1.2, Hose Temperature Control.

Note: On multihose systems a temperature imbalance between hoses can be quickly found by feeling the outside insulation of each hose.

F.4.2 Tank Temperature Check

1. Verify system is not operating in Overtemperature Mode. See Section C.1.4, Overtemperature Indicator Light.

2. Note tank temperature meter reading and adjust tank temperature as required per Section E.1.1, Tank Temperature Control.

F.5 Hose Replacement

Refer to Figure D.3.1

1. Turn OFF unit and allow adhesive in tank to solidify.

*** CAUTION ***
LIQUIFIED HOT MELT ADHESIVE CAN CAUSE DIFFICULTY IN MAINTAINING YOUR UNIT. BE CERTAIN THAT ALL MATERIAL IN THE TANK HAS SOLIDIFIED BEFORE CONTINUING WITH MAINTENANCE.

2. Turn unit back ON for 5 minutes to allow fittings to warm up.

3. Turn OFF hose power switch and pump "ON/OFF" switch.

4. Tilt unit backwards and disconnect hose electrical connector.

5. Loosen hose JIC fitting and remove hose from the fitting on the flow control valve.

MAINTENANCE CONTINUED

F.5 Hose Replacement Continued

6. Pull thermostat bulb out of hose end, being careful not to kink the capillary tube.

7. Remove screws from hose mounting block.

8. Install new hose as specified in Section D.3, Component Mounting and turn ON hose power switch.

F.6 Hose Controller Replacement

1. Follow Steps 1-6 for Hose Replacement, Section F.5.

2. Disconnect melt unit power and open front control panel.

3. Disconnect controller wires.

4. Remove the two 6-32 screws fastening the controller to the electrical mounting panel.

5. Install new controller. Insert thermostat bulb into the hose end and coil the capillary tube so that it hangs in a suitable position beneath chassis.

6. Attach hose the JIC fitting as specified in Section D.3.

7. Reconnect melt unit power, turn ON hose power switch, and adjust controller as indicated in Section E.1.2, Hose Temperature Control.

Note: See also Figure D.3.1 and Section I.2 for switch kit information.

F.7 Pump and Flow Control Replacement

1. Turn OFF unit and allow adhesive in tank to solidify.

2. Turn unit back ON for 5 minutes to allow fittings to warm up.

3. Disconnect melt unit power and tilt unit backwards.

4. Loosen hose JIC fittings and remove hose(s) from the flow control valve.

5. Refer to Section H.1.6 for sequential parts breakdown.

6. Remove the four socket head cap screws attaching the flow control valve and pump to the tank.

7. Pull pump out and remove its O-ring, copper shim, and tank gasket. Provide new replacement seals. (See Section I.2 for appropriate pump kits.)

MAINTENANCE CONTINUED

F.7 Pump and Flow Control Replacement Continued

8. Place O-ring in its pump groove after lubricating with a silicon based grease.

9. Align pump, pump shim, and flow control valve with the O-ring in place. Make certain that the pump and the FCV block mating surfaces lie flat against one another.

10. Attach flow control valve and pump, with the pump gasket seated to the bottom of the tank, using the hex head cap screws with lock washers. Before tightening these screws, check the O-ring groove alignment by manually pressing the flow control valve against the pump. Proceed to tighten all screws in an even manner.

***** CAUTION *****

BE SURE O-RING IS PROPERLY ALIGNED IN PUMP GROOVE WHEN REPLACING PUMP AND/OR FLOW CONTROL VALVE. A PINCHED OR MISALIGNED O-RING MAY RESULT IN PUMP LEAKAGE.

11. Reconnect hose(s) to the flow control valve and turn melt unit power ON.

F.8 Pump Motor Replacement

1. Disconnect electrical power and let melt unit cool to 250 F.

2. Remove motor junction box cover and disconnect wire nuts and 3/8" liquidtight fitting.

3. Remove the four screws fastening the gear box to the motor mounting plate.

4. Lift pump motor off. Remove shaft coupler and key and install it on the new motor.

5. Turn motor shaft so the coupling and key aligns with pump shaft in the tank. Lower motor onto the pump shaft and align it with the mounting plate. Be sure the pump shaft seats properly with the pump.

6. Replace the four motor mounting screws.

7. Replace liquidtight conduit and wires. Reconnect wires, using the wire nuts, according to Section H.2, Electrical Schematic. (See melt unit identification plate to determine exact voltage).

8. Replace junction box cover.

MAINTENANCE CONTINUED

F.9 Overtemp Switch Replacement

***** WARNING *****

THE OVERTEMPERATURE SWITCH IS A NECESSARY SAFETY DEVICE FOR THE PREVENTION OF RUN-AWAY HEATING ON ALL MELT UNITS. UNDER NO CIRCUMSTANCES IS THIS SWITCH TO BE BYPASSED. RUN-AWAY HEATING OF TANK CAN CAUSE HOT MELT MATERIALS TO BURST INTO FLAMES.

1. Disconnect melt unit electrical power.

2. Open the rear panel of the melt unit and locate the O.T. switch. (The KB10 model O.T. switch will be located on the right side of the tank base plate. The KB20 model O.T. switch is located in the same area except it will be mounted to heat transfer plate on the tank base plate.)

3. Remove mounting screws and wires connected to the O.T. Switch. Remove the switch.

4. Apply a small dab of Heat Sink compound on the back side of the replacement O.T. switch. Position the switch in the appropriate location on the tank assembly. Attach switch using mounting screws. (Thread Sealant compound may be required on mounting screws, e.g. KB20. Refer to appropriate replacement kit. See I.5 Lubricants/ Sealants/Cleaners.)

5. Reconnect O.T. switch wires and close rear panel.

Note: The standard overtemperature switch is set for 400° F (205° C). Overtemperature switches with lower settings are available. For higher overtemperature requirements, consult with factory.

F.10 Tank Controller Replacement

1. Disconnect melt unit electrical power.

2. Open front control panel.

3. Remove tank access plate at bottom of electrical panel.

4. Remove wires connected to thermostat. (The tank thermostat controller is the elongated switch mounted horizontally on the tank baseplate.)

5. Remove the two screws holding tank thermostat to tank.

6. Apply even coating of Heat Sink compound to base of the new thermostat. (See Section I.5.)

MAINTENANCE CONTINUED

F.10 Tank Controller Replacement Continued

7. Attach replacement thermostat to the tank assembly using the mounting clip and screws and reconnect wires.

8. Replace tank access plate.

> ***** WARNING *****
>
> FAILURE TO REPLACE THE ACCESS PLATE WILL RESULT IN AN ELECTRICAL HAZARD AND POSSIBLE HEAT DAMAGE TO ELECTRICAL COMPONENTS.

9. Close front control panel.

Note: See Section I.2 for appropriate switch kits.

F.11 Tank Heater Replacement

> ***** NOTE *****
>
> BEFORE CONSIDERING REPLACEMENT, CHECK HEATERS WITH AN AMP-PROBE (SYSTEM POWERED) OR WITH AN OHMMETER (SYSTEM UNPOWERED, HEATER WIRES DISCONNECTED). HEATERS RARELY FAIL. SEE SECTION I.2 FOR APPROPRIATE REPLACEMENT HEATER KITS.

1. Disconnect melt unit electrical power.

2. Open control panel. Disconnect heater wires from terminal blocks.

3. Pull wires behind the electrical panel and grasp wires from the front with pliers and pull heater out of bore.

Note: Should heater not come out easily, it must be driven out by using a 1/4" diameter rod inserted in the knockout holes at the rear of the tank base. Open the rear panel to gain access to the knockout holes.

4. Apply a coating of Heat Release & Transfer Agent to the new heater and slide it into the tank heater bore from the front. (See Section I.5.)

5. Route heater lead wires through the electrical panel and reconnect heater wires in their original locations. (See H.2 Electrical Schematic)

MAINTENANCE CONTINUED

F.12 Maintenance Chart

	Daily	Monthly	Semi-Annual	*As Req.
Check for foreign material in tank.	X		X	
Wipe off excess adhesive from cover.	X			
Purge tank and hoses		X		X
Clean applicator nozzle				X
Check for leaks	X			

* indicates extra maintenance for continuous duty machines

*** NOTES ***

G

TROUBLESHOOTING

This section of the manual has been created for your convenience. In it you'll find many answers to the questions that are common for this machine. If there are any uncertainties concerning the troubleshooting of your machine, please feel free to consult the factory or your local Slautterback representative.

TROUBLESHOOTING CONTINUED

G.1 Tabulation

NOTE:

Read chart from left to right, starting with the **PROBLEM**. Each mark indicates the specific **ITEM TO CHECK** in its particular column. Before each item, there is a number listed which represents a **SOLUTION** found in the following pages. Solutions are listed in a logical order.

PROBLEM \ ITEMS TO CHECK	#1 Main Breaker	#2 Power Connections	#3 Incoming voltage	#4 System wiring	#5 Tank controller	#6 Overtemp switch	#7 Tank Heaters	#8 Supply hose controller	#9 Hose power connector/switch	#10 Supply hose heater	#11 Applicator heater	#12 Pump switch/breaker	#13 Flow control valve	#14 Pump	#15 Pump motor	#16 Foreign material in pump	#17 Adhesive Viscosity too low	#18 Adhesive Viscosity too high	#19 Adhesive Formulation	#20 Plugged applicator nozzle	#21 Nozzle orifice too small	#22 Nozzle orifice too large
a. Tank won't heat up	●	●	●	●	●	●	●															
b. Tank heats slowly			●		●		●															
c. Tank overtemp condition					●	●																
d. Applicator & supply hose heat slowly			●					●			●											
e. Applicator & supply hose fails to heat	●	●	●					●	●	●	●											
f. Applicator & supply hose overheats			●					●			●											
g. Pump inoperative	●		●									●		●	●	●						
h. Pump motor stalls					●								●		●	●		●	●			
i. Pump motor overload					●							●	●		●	●		●	●			
j. Pump motor breaker throws			●	●								●	●		●							
k. Pump leaks														●								
l. Adhesive output too low					●			●					●	●	●	●		●	●	●	●	
m. Adhesive output too high					●			●					●		●		●					●
n. Excessive smoking from tank and gun					●			●						●					●			
o. Irregular noise														●	●							

TROUBLESHOOTING CONTINUED

G.2 Solutions

Note: The following solutions directly correspond with the solution numbers listed on the preceding page.

1. Turn the main power breaker switch to the "ON" position. If switch light fails to illuminate, the switch may need replacement.

2. Inspect the power-in connections for proper fit and check for faulty wires. Also inspect the hook-up of the power wires or power plug at the main power supply source.

3. Determine exact voltage of the melt unit. (See Section D.6, Power Requirements)

   Problem d. Determine exact heater voltage of the adhesive applicator and supply hose, (found on the identification tags).

   Problem g. Determine exact voltage and frequency of the pump motor marked on the motor itself.

*** NOTE ***
INSUFFICIENT VOLTAGE CAN BE THE CAUSE OF THESE PROBLEMS. VOLTAGE DROPS ARE COMMON. USE A VOLTMETER TO DETERMINE WHETHER SUFFICIENT VOLTAGE IS SUPPLIED TO THE MACHINE.

*** CAUTION ***
THE VOLTAGE OF EACH MELT UNIT COMPONENT MUST BE THE SAME AS THE VOLTAGE OF THE MELT UNIT ITSELF OR SERIOUS DAMAGE TO THE SYSTEM WILL OCCUR.

4. Refer to the Electrical Schematic (Section H.2) and check the actual wire connections to ensure that the melt unit is wired properly. If problem still exists, check the status of specific components with a voltmeter (system powered), or with an OHM meter (system unpowered, wire disconnected).

5. Adjust the tank temperature controller according to Section E.1.1 of this manual. Inadequate tank heat can affect the performance of your hot melt system. If problem still persists, see Tank Controller Replacement (Section F.10).

TROUBLESHOOTING CONTINUED

G.2 Solutions Continued

6. The overtemperature (O.T.) switch is a safety device designed to prevent the tank from reaching a "run-away" temperature condition. Once the tank reaches an overtemp condition, the O.T. switch controls tank temperature. Check tank temperature when the O.T. indicator is lit.

   If tank temperature is too high, turn tank controller down (counter-clockwise). If the O.T. light is on at an acceptable, or low tank temperature, the O.T. switch is either faulty or rated at a low temperature. The O.T. switch must be replaced in either case. (See Section F.9, O.T. Switch Replacement and Section I.2 for switch kits.)

7. See Solutions #1 through #6. If problem still exists, replace the tank heaters as specified in Section F.11, Tank Heater Replacement.

8. Adjust the hose temperature controller according to Section E.1.2 in this manual. Inadequate supply hose heat can affect the performance of your hot melt system. If problem persists, see Hose Controller Replacement, Section F.6, and Section I.2 for hose controller kits.

9. Check the incoming hose power connector to see if it is properly installed. Connector wire pins may be misaligned or loose. If the melt unit has a "HOSE PWR" switch, turn it to the "ON" position.

10. See Solutions #1, #2, #3, #8, and #9. If problem remains, disconnect incoming hose power connector and check hose heater resistance with an ohmmeter. If the hose heater has failed, it is necessary to replace the hose. (See the appropriate hose service manual)

11. See Solutions #3 and #9. Touch applicator to determine if it is heating. Refer to the appropriate handgun/hose or E100 service manual.

TROUBLESHOOTING CONTINUED

G.2 Solutions Continued

12. Turn the pump on/off breaker to the "ON" position. Verify that the L1S handgun switch is operational, or that the gun hanger switch is in the relaxed or ON position.

Note: Allow sufficient time for the melt tank to reach operating temperature. This will cause the pump warm-up switch to close, thus completing the pump-motor circuit.

Problem i. When the pump motor experiences overload conditions, it will shut off, or the pump motor breaker will throw, or both. This is usually caused by insufficient pump warm-up time. If this problem persists, pump switch/breaker may need replacement.

Problem j. See Solutions #3, #13, and #15. Replace pump breaker.

13. Adjusting the Flow Control Valve (F.C.V.) correctly will produce the desired pumping performance of your melt unit. (See Section E.2 of this manual.) If the F.C.V. is inoperable, replace or repair it as specified in Section F.7. (See Section I.2 for pump kit information.)

14. Determine which pump is mounted in your melt unit. (See Section H.14, Parts List and the melt unit I.D. plate) The pumping performance, listed in Section B.3 of this manual, depends upon certain pump and pump motor combinations. (See Section F.7, Pump Flow Control Replacement and Section I.2 for pump kit information.)

Problem g. Look into the melt tank for any foreign material plugging the insert pump port. Pump gears can freeze up, in which case the pump may need replacement or repair.

Problem k. Tighten F.C.V. and pump mounting screws. If pump continues to leak, replace the O-ring, copper shim, and tank gasket.

Problem l. Consult factory for the proper pump combination needed for specific application.

Problem n. The pump may have excessive wear. Dismantle and determine its status. Replace if necessary.

TROUBLESHOOTING CONTINUED

G.2 Solutions Continued

15. The pump motor is normally the last item to check when troubleshooting. All motors have internal thermal protection. Turn off pump switch and allow motor to cool for approximately 20 minutes. Turn pump switch back on. If the motor still fails to operate, continue troubleshooting. Determine which pump motor is mounted in your melt unit. (See Section H.1.4, Parts List and the motor I.D. plate.)

    Problem g. Disconnect motor from melt unit voltage and apply test voltage to determine the operational status of the motor. Replace the motor if necessary.

    Problems l & m. Consult factory for the properly rated pump motor for your specific application. (See Section F.8, Pump Motor Replacement.)

16. Remove foreign material from pump and tank. Purge system with "Strip-N-Clean" if necessary.

17. Decrease tank and supply hose temperatures. If this does not improve performance, consult the adhesive vender concerning your applications.

18. Increase tank and supply hose temperatures. If this does not improve performance, consult the adhesive vendor concerning your applications.

19. Adhesive formulations tend to be a factor in each previously listed problems. Refer to Start-Up Instructions (Section D.7), for Cautionary Notes. System should be purged.

20. Clean applicator nozzle. (See Section I.4, Maintenance Tools.)

21. Increase system fluid pressure without stalling the motor (F.C.V. adjustment). If this does not work, remove nozzle and replace it with a larger orifice nozzle.

22. Decrease system fluid pressure (F.C.V. adjustment). If this does not work, remove nozzle and replace it with a smaller orifice nozzle.

H

PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC

H.1 Parts Lists and Assembly Drawings

H.1.1 Melt Unit Parts List

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	73010	Tank Assy, KB 10
	1	73198-2	Tank Assy, KB 20 W/Polyamide Tank
2	1	70600	Chassis Base
3	4	14468	Spacer, 21/64 x 3/4 x 1/2 Thk
4	4	14451-IA	Washer, Lock 5/16 I.D.
5	4	14433-IAM	Screw, Hex HD. 5/16-18 x 1-1/4"
6	1	13011-4	Thermostat w/Slot
7	1	13011-3	"C" Mounting Clip
8	7	14530-CAW	Screw, PHIL Self Tap 6-32x5/16"
9	6	14451-CA	Washer, #6 Lock
10	1	79056-1	Pump Warm-up (lock-out) Switch
11	1	* Overtemp Switch Kit see Section I.2	
12	1	70589	Plate, O.T. Switch Mounting KB 20
13	2	14431-FDF	Screw, SOC HD CAP 10-32 x 1/2"
14	1	70146	Melt Grid
15	4	14431-IDD	Screw, SOC HD 5/16-18 x 3/8" Lg
16	2	12532	Heater, 6"x1/2" 350W, 120V KB 10
	2	12538	Heater, 6"x1/2" 350W, 240V KB 10
16	2	12546-2	Heater, 6"x1/2" 600W, 120V KB 20
	2	12546-1	Heater, 6"x1/2" 600W, 240V KB 20
17	1	* Flow Control and Pump see Section H.1.6	
18	1	* Front Panel see Section H.1.3	
19	1	* Inside Electrical Panel see Section H.1.4	
20	1	70110	Insulation, Tank KB 10
	1	70110-1	Insulation, Tank KB 20
21	2	14403-CDF	Screw, Set 6-32 x 1/2"
22	1	14441-CA	Nut, 6-32
23	4	14432-FDD	Screw, BUT HD SOC 10-32 x 3/8"
24	1 ea	73706-11	Cable Assy, Gun/Hose #1 (9-pin)
	1 ea	73706-12	Cable Assy, Gun/Hose #2 (9-pin)

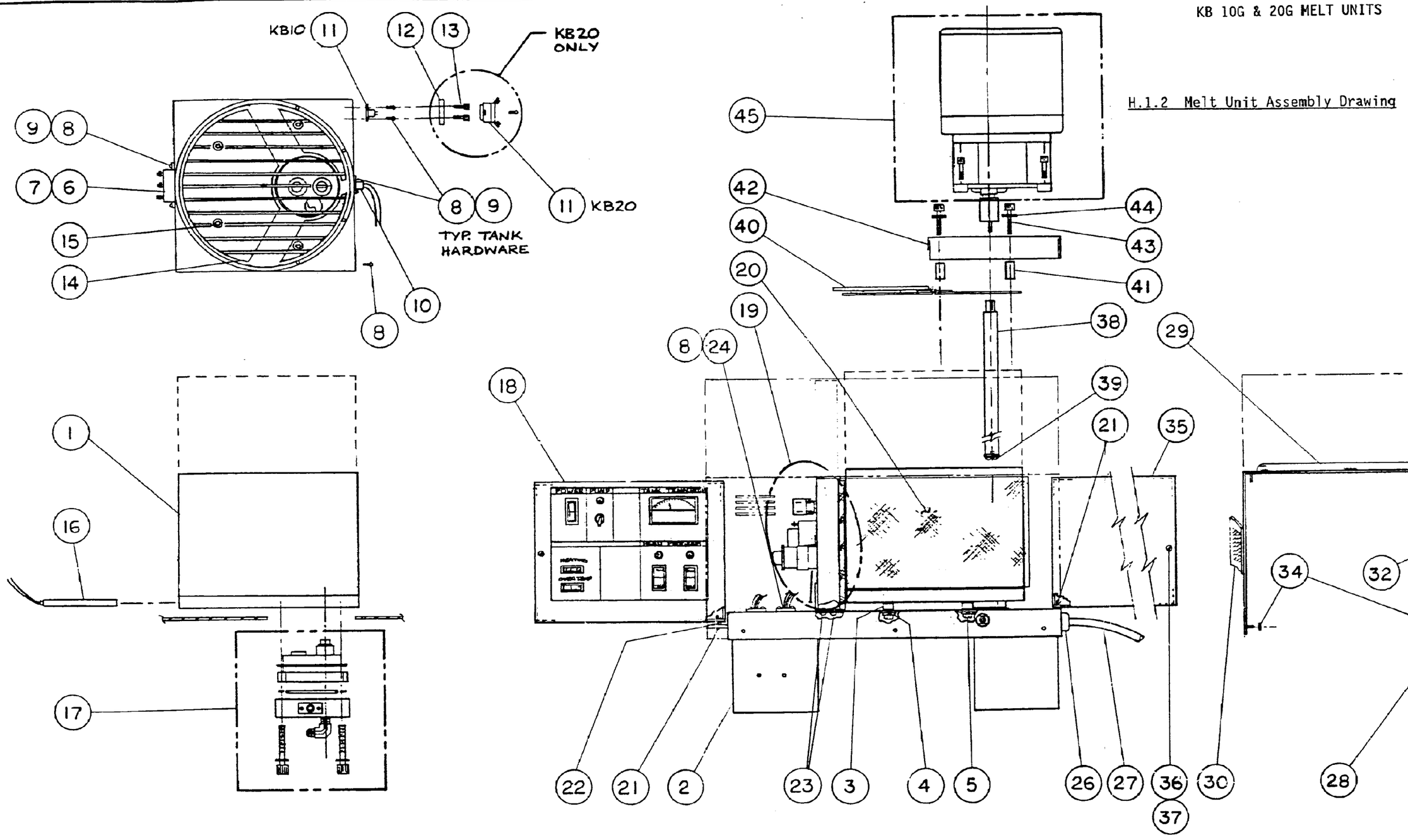
PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC CONTINUED

H.1.1 Melt Unit Parts List Continued

ITEM	QTY	PART NUMBER	DESCRIPTION
26	1	12222	Bushing, Strain Relief (120V)
			Bushing, Strain Relief (240V)
27	1	12012	Power Cord, 8' 120V w/plug
			Power Cord, 10' 240V w/out plug
28	1	70584	Housing, Tank KB10
	1	70584-1	Housing, Tank KB20
29	2.2 ft.	70020	Housing Seal
30	2	70237-48	Label, "KB 10"
	2	70237-49	Label, "KB 20"
31	2	70026	Label, "HOT" (not shown)
32	2	14502-1	Clip, Retainer for panel
34	6	14441-DA	Nut, 10-32
35	1	70585	Rear Panel, KB 10
	1	70585-1	Rear Panel, KB 20
36	1	14501-2	Screw, Retaining
37	1	14503-1	Washer, Retaining
38	1	70461-3	Pump Shaft, KB 10
	1	70461-4	Pump Shaft, KB 20
39	1	70028	Pump Shaft Retainer
40	1	73526-1	Lid Sub-Assy
41	4	14471-1	Spacer, .250 x .500 x 1" LG
42	1	70458-2	Motor, Mount Pan
43	4	14431-DDO	Screw, SOC HD CAP 8-32 x 1 3/4"
44	4	14451-DA	Washer, Lock #8
45	1	* Motor Assy	see Section H.1.5
46	1	73733-1	Wiring Harness, Tank KB 10
	1	73733-3	Wiring Harness, Tank KB 20

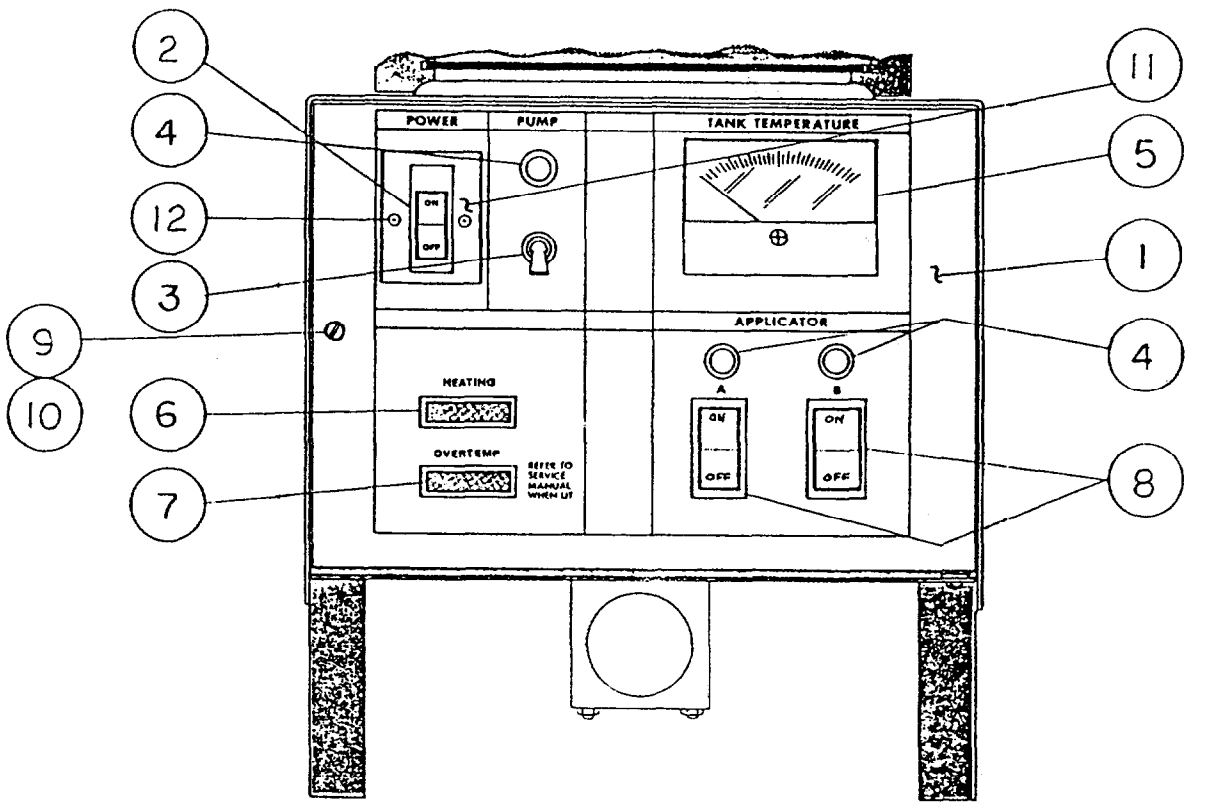
Note: Refer to Section I.1.3 for part numbers relating to the Gun Hanger Switch.

H.1.2 Melt Unit Assembly Drawing



PARTS LISTS, ASSEMBLY DRAWINGS AND
ELECTRICAL SCHEMATIC CONTINUED

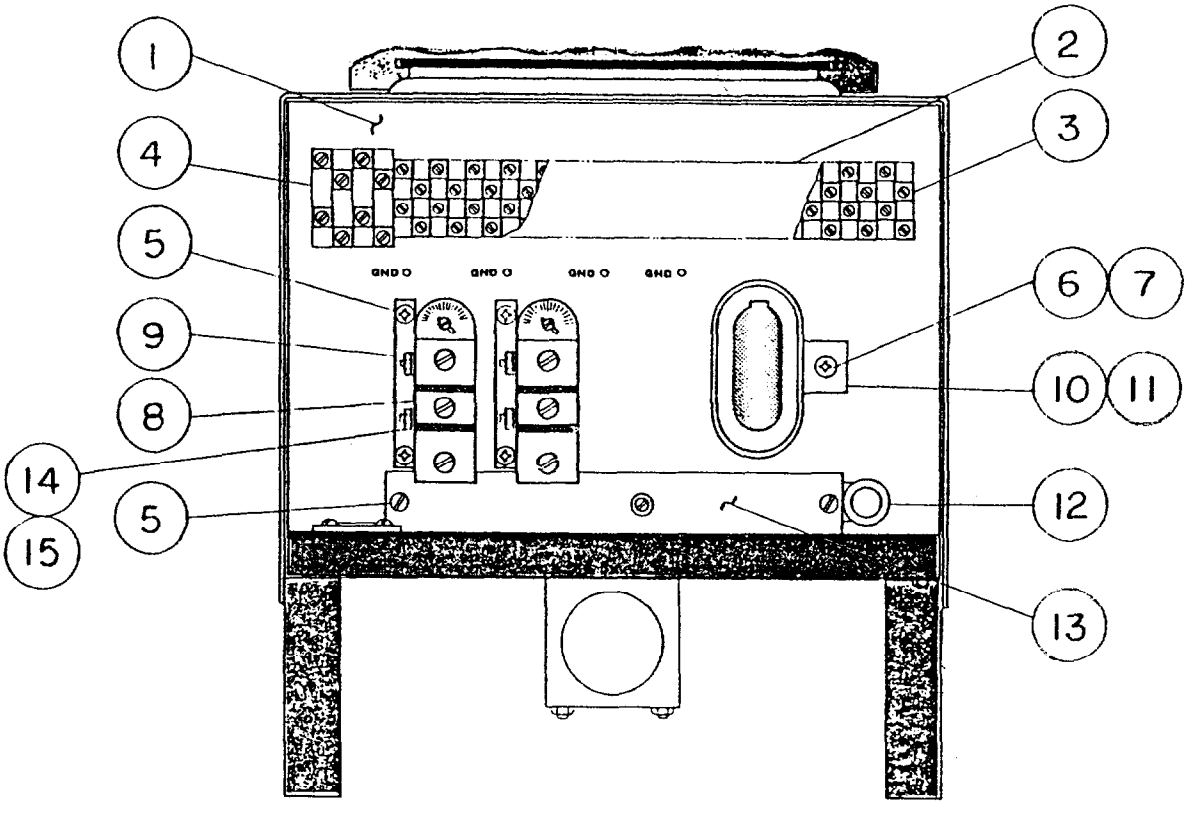
H.1.3 Front Panel



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	70586-1	Front Panel, KB 10
	1	70586-3	Front Panel, KB 20
2	1	12015-1	Rocker Breaker, 15 amp, 120V KB 10
	1	12015-2	Rocker Breaker, 20 amp, 120V KB 20
	1	12015-3	Rocker Breaker, 12 amp, 240V
3	1	12055-2	Pump "ON/OFF" Breaker, 120V
	1	12055-1	Pump "ON/OFF" Breaker, 240V
4	2 or 3	12030-9	Lamp, White
5	1	12006	Tank Temperature Meter
6	1	12044-10	Light, Rectangular Amber
7	1	12044-2	Light, Rectangular Red
8	1 or 2	12011-4	Switch, DPST "ON/OFF"
9	1	14501-2	Screw, Retaining
10	1	14503-1	Washer, Retaining
11	1	70702	Plate Switch 120V
	1	70703	Plate Switch 240V
12	2	14470-1	Rivet, Pop Type 1/8 DIA
13	1	73707-12	Wiring Harn,Fr. Pnl. 120V (not shown)
	1	73707-14	Wiring Harn,Fr. Pnl. 240V (not shown)

PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC CONTINUED

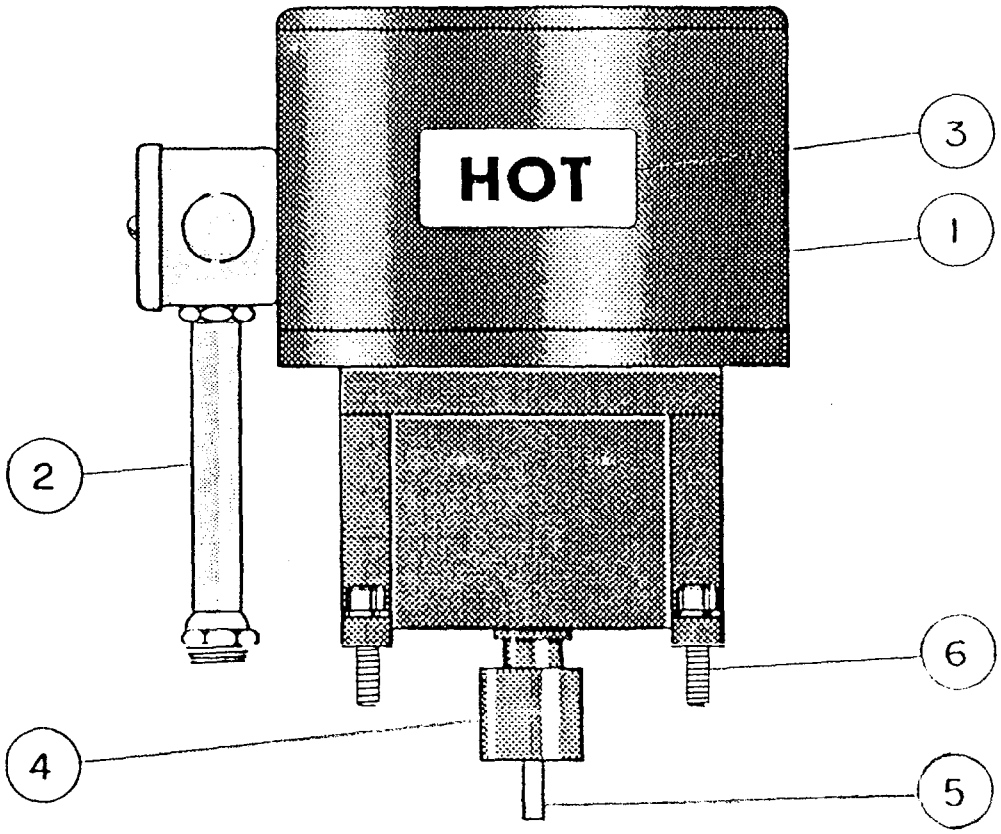
H.1.4 Inside Electrical Panel

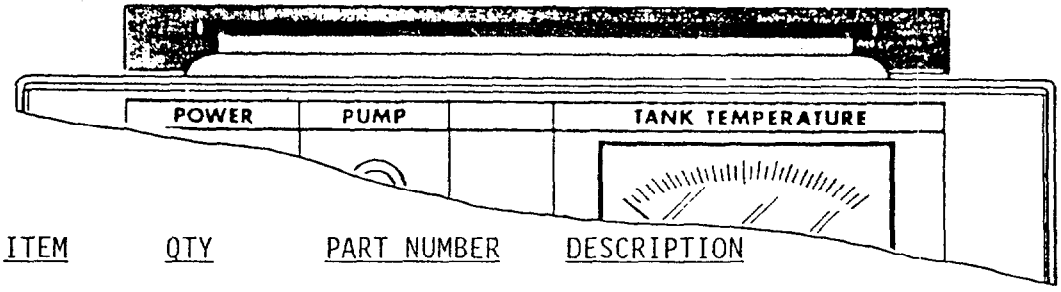


ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	70583	Electrical Mtg. Panel, KB 10
	1	70583-2	Electrical Mtg. Panel, KB 20
2	1	70360	Terminal Rail, KB 10
3	8	12021-3	Terminal Block (NT4) White
4	2	12021-5	Terminal Block (NFT1) Blue
5	17	14530-CAW	Screw, PHIL Self-Tap 6-32 x 5/16"
6	1	14530-DAW	Screw, PHIL Self-Tap 8-32 x 5/16"
7	1	14451-DA	Washer, Lock #8
8		13026-1	Hose Controller 100-200 F
		13026-2	Hose Controller 200-300 F
	1 to 4	13026-3	Hose Controller 300-400 F (Std)
		13026-4	Hose Controller 350-450 F
9	1 to 4	13026-BKT	Bracket, Panel Mount for 13026-
10	1	12045-2	Capacitor, 5 MFD, 320 vac
11	1	18417-1	Capacitor Bracket
12	1	14531-5/8	Grommet, 5/8" I.D.
13	1	70583-1	Control Access Plate, KB 10
14	11	14452-CA	Washer, Lock Internal #6
15	8	14441-CA	Nut, Hex 6-32

PARTS LISTS, ASSEMBLY DRAWINGS AND
ELECTRICAL SCHEMATIC CONTINUED

H.1.5 Motor Assembly



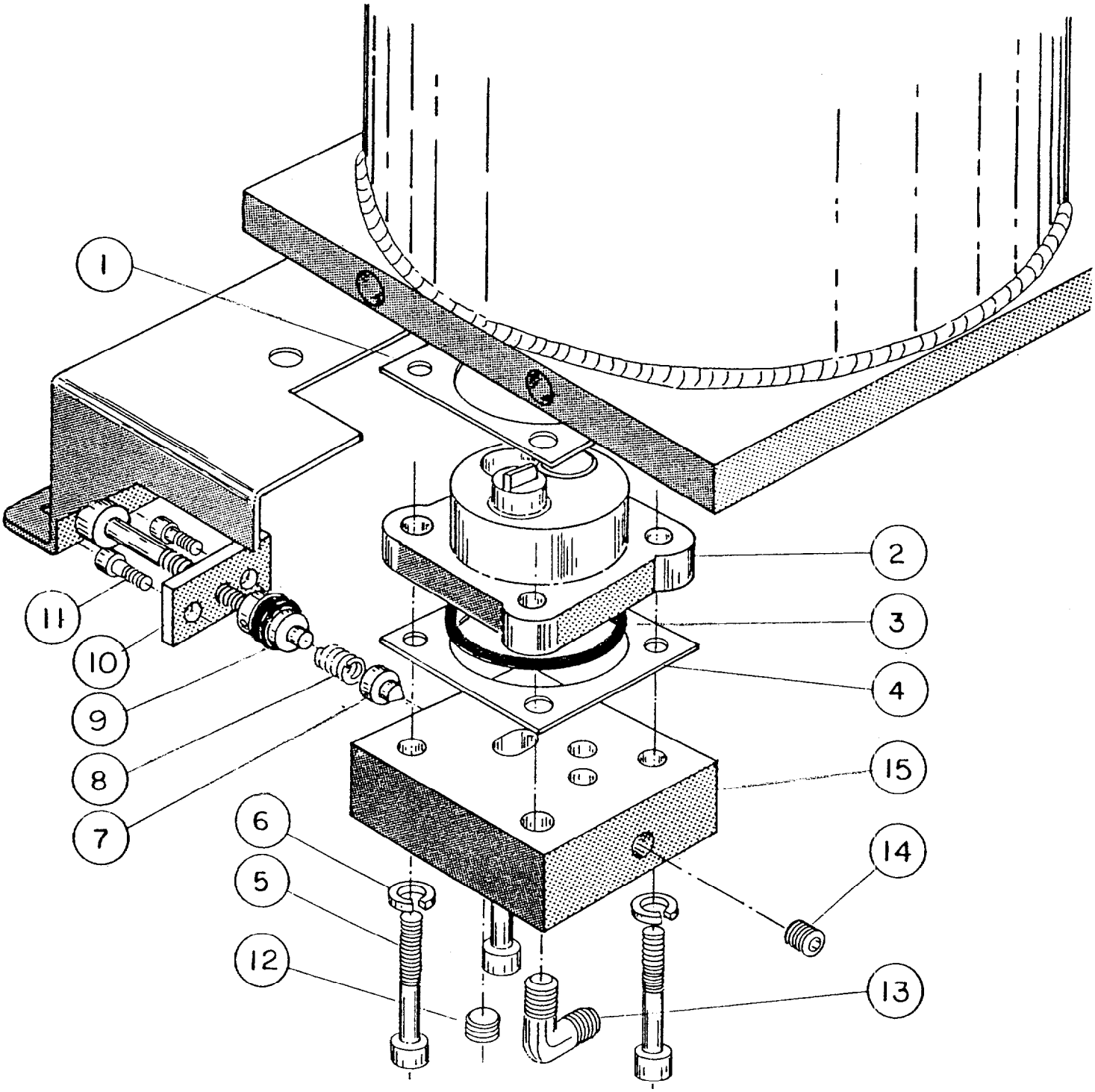


ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	73052-1	Motor Assy, 86RPM, 120V/50-60Hz
	1	73052-2	Motor Assy, 86RPM, 240V/50-60Hz
2	1	73527-1	Motor Conduit Assy
3	1	70237-3	Label, "HOT"
4	1	70460-2	Coupler
5	1	14475-3	Key, 1/8" x 1/8" x 1"
6	4	14431-GDI	Screw, SOC HD CAP 1/4-20x3/4"

Note: See Sections H.1.3 and H.1.4 for matching motor breaker and capacitor.

PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC CONTINUED

H.1.6 Flow Control and Pump



PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC CONTINUED

H.1.6 Flow Control and Pump

ITEM	QTY	PART NUMBER	DESCRIPTION
*	1	* Pump Kit see Section I.2	
1	1	70118	Gasket, Pump
2	1	73159-11	Pump, 21 mm
		73159-12	Pump, 30 mm
3	1	10545	"O"-Ring, 21 mm Pump
		10438	"O"-Ring, 30 mm Pump
4	1	70032	Shim, Pump
5	4	14431-GDO (21mm)	Screw,SOC HD CAP 1/4-20 x 1 3/4"
		14431-GDQ (30mm)	Screw,SOC HD CAP 1/4-20 x 2 1/4"
6	4	14451-GA	Washer, Lock 1/4"
*	1	75011-006	F.C.V. Assy, 1 Hose
*	1	75011-007	F.C.V. Assy, 2 Hose
7	1	70392-1	Damper, F.C.V.
8	1	14489-10	Spring, F.C.V.
9	2	10412	"O"-Ring, Piston Assy
10	1	73051	Piston Assy, F.C.V. w/"O"-Rings
11	2	14431-FDF	Screw,SOC HD CAP 10-32 x 1/2"
12	1 or 0	11603-4D	Plug, 1/4" NPT
13	1 or 2	11409-64A	Elbow Fitting, 1/4 NPT to #6 JIC
14	1	11603-2D	Plug, 1/8 NPT
15	1	70123-5	F.C.V. Block
16	1	11050-1/4	F.C.V. Wrench, 1/4" Hex (not shown)

PARTS LISTS, ASSEMBLY DRAWINGS AND ELECTRICAL SCHEMATIC CONTINUED

H.2 Electrical Schematic

Current electrical schematics are located in a pocket on the back panel of the melt unit and inside the manual binder.

I

KITS AND SPARES

*** NOTE ***

THE FOLLOWING MISCELLANEOUS ITEMS ARE SUGGESTED FOR SYSTEM MAINTENANCE AND USER CONVENIENCE. THEY ARE PRESENTED IN A MANNER WHICH REFLECTS THE CURRENT OPERATIONAL STATUS OF YOUR MELT UNIT. CONSULT YOUR LOCAL SLAUTTERBACK REPRESENTATIVE FOR CURRENT PRICES.

I.1 Special Options

I.1.1 Pump Warm-up Switch (Standard)

This is a close-on-rise thermostat which prevents the motor from running before the system has had time to come up to the operating temperature. While it is not necessary for the safe operation of the machine, it does prevent the motor thermal cutout or breaker from shutting the motor off should the motor be operated prior to the required warm-up time of the system. (S.C. kit #79056-1)

I.1.2 Gun Hanger Switch Kits

The Gun Hanger Switch Kit deactivates the pump motor when a L1 Handgun/Hose is hanging on the hanger. It activates the pump motor when the handgun is removed from the hanger and the front panel pump "on/off" breaker switch is in the "ON" position. Gun Hanger Switch Kits are designed and recommended to increase pump motor life.

There are three kits available. The standard gun hanger switch kit, #79063-11, is mounted directly onto the melt unit chassis. Remote mounted switch kits allow the user to hang his/her L1 Handgun/Hose in a location approximately 8 or 12 ft. from the melt unit. (S.C. kit #79063-8 and 79063-12)

KITS AND SPARES CONTINUED

I.2 Melt Unit Recommended Spares

S.C. Part #	Description	Minimum	Optimum
	Heaters		
79005	Kit, Tank Heater KB 10 120V 350W	1	1
79005-1	Kit, Tank Heater KB 10 240V 350W	1	1
79044-1	Kit, Tank Heater KB 20 120V 600W	1	1
79044	Kit, Tank Heater KB 20 240V 600W	1	1
	Switches		
79006	Kit, Tank Controller	1	1
79125-3	Kit, Hose Controller 300-400° F	1	2
79125-1	Kit, Hose Controller 100-200° F	-	1
79125-2	Kit, Hose Controller 200-300° F	-	1
79125-4	Kit, Hose Controller 350-450° F	-	1
79126-300	Kit, Overtemp Switch 300° F KB 10	-	1
79126-400	Kit, Overtemp Switch 400° F KB 10	1	1
79126-425	Kit, Overtemp Switch 425° F KB 10	-	1
79126-450	Kit, Overtemp Switch 450° F KB 10	-	1
79127-300	Kit, Overtemp Switch 300° F KB 20	-	1
79127-400	Kit, Overtemp Switch 400° F KB 20	1	1
79127-425	Kit, Overtemp Switch 425° F KB 20	-	1
79127-450	Kit, Overtemp Switch 450° F KB 20	-	1
12015-1	Rocker Breaker 120V 15 AMP, KB 10	1	1
12015-2	Rocker Breaker 120V 20 AMP, KB 20	1	1
12015-3	Rocker Breaker 240V 12 AMP	1	1
79056-1	Pump Warm-up (lock-out) Switch	-	1
	Kit, Hose Power Switch #2	-	1
	Pumps		
79048-2	Kit, Pump 30mm	1	1
79042	Kit, Hardware Pump 30mm & 21mm	1	2
79081	Kit, Pump Seal 30mm & 21mm	1	2
79030-1	Kit, Pump 21mm	-	1
79082-1	Kit, F.C.V. Repair (minor-seals only)	1	2
79082-2	Kit, F.C.V. Repair (major - complete)	-	1
79082-3	Kit, F.C.V. Field Retrofit - KB	1	1
75011-006	Flow Control Valve Assy, 1 Hose	-	1
75011-007	Flow Control Valve Assy, 2 Hose	-	1

KITS AND SPARES CONTINUED

I.2 Melt Unit Recommended Spares Continued

*** NOTE ***

INDIVIDUAL MOTORS, HARDWARE, CAPACITORS, AND PUMP MOTOR "ON/OFF" BREAKERS ARE FOUND IN SECTIONS H.1.4 AND H.1.5. BE CAREFUL TO ORDER MATCHING COMPONENTS. MOTOR GROUPS LISTED BELOW INCLUDE THESE COMPONENTS PRE-ASSEMBLED (WITHOUT MOTOR MOUNT PAN).

	Motors		
73714-1	Motor Group, 86 RPM 120V 60Hz	1	1
73714-2	Motor Group, 86 RPM 240V 60Hz	1	1
12277-2	Wire Nuts (Medium low temp.)	6	12
70460-2	Motor Coupler KB	1	1
14475-3	Key, 1/8" x 1/8" x 1"	1	2
70461-3	Pump-Motor Shaft KB 10	-	1
70461-4	Pump-Motor Shaft KB 20	-	1
70028	Retaining Ring, Pump Shaft	-	2

I.3 Maintenance Spares

S.C. Part #	Description
11409-64A	Male Elbow, #6 JIC to 1/4" NPT pipe
11423-64A	Fitting, Straight M. 1/4" NPT to #6 Fm. JIC
11421-6B	Cap, #6 JIC
11603-4D	Pipe Plug, 1/4" NPT
12198	Wire Nut (Small high temp.)
12199	Wire Nut (Medium high temp.)
12277-1	Wire Nut (Small low temp.)
12277-2	Wire Nut (Medium low temp.)
15850-3/8	3/8" Liquidtight Conduit (by the foot)
12008-00-3/8	Straight Connector (conduit)
12008-45-3/8	45 deg. Angle Connector (conduit)
12008-90-3/8	90 deg. Angle Connector (conduit)
30087	Hose Support Hammock (Sling)
11030	Hose Balancer 1 - 4 lb. Tension
11031	Hose Balancer 2 - 5 lb. Tension
15751-250	Armorflex Conduit, 1/4" I.D., .350 O.D.
15751-375	Armorflex Conduit, 3/8" I.D., .480 O.D.
15751-500	Armorflex Conduit, 1/2" I.D., .625 O.D.
10901-xx-(0)	Shrink Tubing, Thin Wall, black (xx-size)
10900-xx	Shrink Tubing, Medium Wall, black
11416-6A	Elbow, 90 Deg. #6 M. JIC to #6 Fm. JIC
11420-6A	Elbow, 45 Deg. #6 M. JIC to #6 Fm. JIC

KITS AND SPARES CONTINUED

I.4 Maintenance Tools

Safety Equipment

S.C. Part #	Description
11091	Safety Goggles
11068-1	Safety Gloves (Heat)
11063	Rubber Gloves, Liquidproof (Solvent)

Teletherm Portable Pyrometer

S.C. Part #	Description
30154-F (Fahrenheit)	Meter, case, all three probes, and accessory kit.
30154-C (Centigrade)	
30153-F (Fahrenheit)	Meter only, with case (without probes)
30153-C (Centigrade)	
11079-1	Bead probe
11079-2	Surface probe
11079-3	Immersion/ambient probe
11080-1	Accessory kit: extra long 5' cable, holding brake, and fixing clip

Various Accessories

S.C. Part #	Description
11029	Pocket thermometer
11025	Amp Probe
11026	Volt Ohmmeter
12021	Adjustable "Flameless" heat gun
11022-1	Hex Key Set .050" through 3/16"
11022-2	Hex Key Set 5/64" through 1/4"
11022-3	Hex Key Set 3/32" through 1/4"
11022-4	Hex Key Set 3/16" through 3/8"
11023-2	Bore Brush 7/8" O.D.
11023-1	Bore Brush 1/4" O.D.
11024	Stainless Steel Brush (small)
11024-1	Stainless Steel Brush (large)
11048-1	Razor Knife
11049-1	Blades for Razor Knife
11027	Wire Stripper
11043	Universal Crimp Tool
11042-2	Amp Pin Extractor
11003	Amp Pin Crimp Tool
79002	Nozzle Cleaning Kit, L1 Handgun
73124-1	Slautterback Tool Kit (5 piece)
73124-2	Slautterback Tool Kit (complete)

KITS AND SPARES CONTINUED

I.5 Lubricants/Sealants/Cleaners

S.C. Part #	Description	Applications
30096	Seal Lubricant, 1 oz. syringe	O-rings, rubber seals
11278	Heat Sink Compound 5 oz. tube	Thermally activated switches
11277	Thread Sealant 1.69 oz. tube	All types of threaded connections
11276-1 (clear) 11276-2 (black)	Silicone Sealant 11.6 oz. cart.	All-purpose, high temp adhesive sealant
11200-1 11200-5 11200-55	Strip-N-Clean #9 1 gallon 5 gallons 55 gallons	Hot melt system cleaning & flushing solution
11203-4	Parts-Soak 4 gal. with basket	Heavy duty parts soaking solution
11207	Heat Release & Transfer Agent 6 oz.	Heaters

*** NOTES ***

*** NOTES ***

*** NOTES ***

SLAUTTERBACK®

PRODUCT MANUAL FEEDBACK FORM

Fax it to us at (831) 658-6096

Please help us improve our manual. Send this form with any suggestions you may have.
We will get back to you as soon as possible.

Date_____

Your name_____ Company_____

Telephone number_____ Fax number_____

Manual Title_____ Manual # 19600-_____ Revision_____

Manual publication date_____ Section(s)_____ Page(s)_____

Type of error:

- ❒ Typo/grammar/format
- ❒ Information incorrect
- ❒ Information to be added
- ❒ Information to be deleted
- ❒ Illustration incorrect
- ❒ Other (explain below)

Description of change(s) [attach marked-up sample pages if possible].
Use an additional sheet of paper if necessary.

_____

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Comments: _____

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For factory use only

Technical Document Review Committee:

Change implemented? ❒ Y ❒ N Reason _____

_____

Date implemented_____ Approved by_____ Date _____

Feedback to sender date _____

06/07/00

Slautterback Corporation ❒ 5 Lower Ragsdale Drive Monterey CA 93940-5779 USA ❒ 831/658-6000

SLAUTTERBACK®

Warranty

07/00

A. Slautterback Corporation warrants its products, when operated and maintained in accordance with Slautterback recommended procedures, are free of defects in material and workmanship during the periods indicated below commencing with the date the product is placed in service.

Product	Warranty Period
1. Tank heater (including entire tank when heater is cast into tank)	5 years or 10,000 hours of use, whichever occurs first
2. Melt unit (unless specified below); pattern controller; head driver	2 years or 4,000 hours of use, whichever occurs first
3. Stationary hose; automatic electric head; JR™ Series Hotmelt System or melt unit; standard pail unloader; standard accessory purchased with a system	1 year or 2,000 hours of use, whichever occurs first
4. Manual hose; handgun; Mini Squirt III; any butyl system; any PUR system (including hose, gun or head used with PUR); any spare or replacement component; pneumatic head; industrial heated hose; T100 Temperature Controller; nozzle; nozzle bar	6 months or 1,000 hours of use, whichever occurs first
5. Rebuilt equipment	90 days or 500 hours of use, whichever occurs first

B. The sole liability of Slautterback and exclusive remedy extended to any Slautterback customer shall be limited to replacing or repairing, at the option of Slautterback, any product returned under the terms of this warranty. Labor and related expenses incurred to install replacement or repaired parts are not covered by this warranty.

C. Slautterback is not responsible for repair or replacement of any product that has been subject to abuse, misuse, alteration, accident, or negligent use, nor for repairs made by an unauthorized person or with parts other than those provided by Slautterback.

D. Slautterback assumes no responsibility for the performance of adhesives or other materials used with its products.

E. The warranty for a product repaired or replaced under this warranty shall continue in effect for the remainder of the original warranty period, or for ninety (90) days following the day of shipment by Slautterback of the repaired or replaced product, whichever period is longer.

F. No warranty is made with respect to custom products or products developed, designed and manufactured to customer specifications, except as specifically stated in writing by Slautterback.

G. Slautterback is responsible only for payment of shipping charges for delivery of a repaired or replaced product, via the least expensive means of transport, to customer or an authorized Sales and Service Center in the Continental United States only. Payment for shipment to Slautterback or an authorized Sales and Service Center for evaluation, repair or replacement is the responsibility of the customer.

H. For service under this warranty contact the Factory Authorized Representative from which the product was purchased.

THIS WARRANTY IS IN LIEU OF ANY OTHER WARRANTY EXPRESSED OR IMPLIED, INCLUDING THE WARRANTY OF MERCHANTABILITY AND FITNESS FOR THE PARTICULAR PURPOSE.

Complete Reverse Side and Retain for Your Records

Equipment Record

Record the information below on all equipment received and retain for your records.
(Systems, melt units, hoses, guns, heads, pattern controllers, drivers, etc)

Products were purchased from:______________________________
Slautterback Authorized Sales and Service Center

Product Model/Description______________________ Serial No.__________
Product Part Number______________________ Order No.__________
Date Received__________ Start-Up Date__________ Invoice No.__________

Product Model/Description______________________ Serial No.__________
Product Part Number______________________ Order No.__________
Date Received__________ Start-Up Date__________ Invoice No.__________

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